

Work Order ID 59636

Wednesday, June 09, 2010 9:45:29 AM



Page 1

Item ID: D3174-1

Accept



Setup Start



Revision ID:

Item Name: Mounting Lug

Stop



Start Date: 6/9/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 6/17/2010 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-6-09

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3174

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3174

☐ Dwg Rev: A1

☐ Prog Rev: A1

☐ 2-

Deburr if necessary

304 .063

10-6-22

(10)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-6-22

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8/10/06/24

(110)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Debur if necessary

= 7 m-h 10/06/23

(10X)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

8 w/06/24

(76)

150



Packaging

Packaging

Identify as per dwg & Stock Location: CALL

0.00

Memo

0.00

8/14/25 (10)

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/28 JF

C210/6/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 09, 2010 9:45:33 AM

Page 1

Work Order ID: 59636



Parent Item: D3174-1



Parent Item Name: Mounting Lug

Start Date: 6/9/2010

Required Date: 6/17/2010

Comments: IPP: ☐A☐03.01.29☐New issue☐KJ/RF☐

Start Qty: 8.00

Required Qty: 8.00

IPP Rev:B 08-08-19 now made on water jet DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	128.0000	0.0408	0.343579	.41		



304/316 Sheet .063



810-6-22

Location

Loc Qty

Loc Code

MAT

128

111323

0

114799

128

114799

(10)

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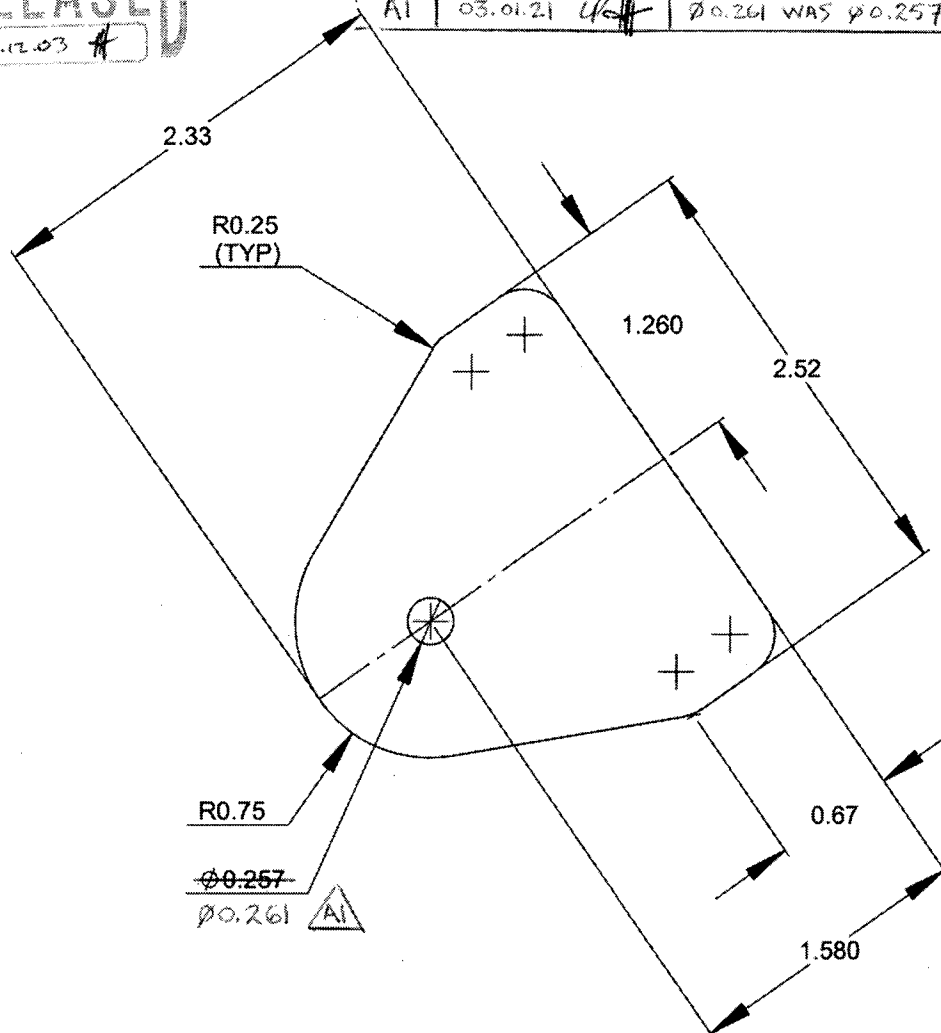
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DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3174	REV. A SHEET 1 OF 1
DATE 02.12.03	TITLE MOUNTING LUG		SCALE 1:1
A	02.12.03	NEW ISSUE	
A1	03.01.21 <i>UP</i>	Ø0.261 WAS Ø0.257	

RELEASED
02.12.03 *#*



D3174-1 MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 59636
BS10-6-09

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.063 THICK
(REF. DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005-0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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